

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE KIT		
Job Number	: 31218				
Estimate Number	: 10532				
P.O. Number	: N/A	Part Number	: K10003		
This Issue	: 3/14/2007 S.O. No. : N/A	Drawing Number	: K10003		
Prsht Rev.	: NC	Project Number	: N/A		
First Issue	: 3/14/2007 Type : SMALL /MED FAB	Drawing Revision	: C		
Previous Run	: 31129	Material	: N/A		
Written By	:	Due Date	: 3/26/2007	Qty:	8 Um: Each
Checked & Approved By	:				
Comment	:				
	Est: I 03.01.16 Reformat: Incorporated D205-641-011				
	KJ/RF				
	Est: J 06-07-25 As per DSI 9344				
	JLM				
	Est: K 06.11.17 Per K10003 Rev C				
	KJ				
	Est Rev: L 07.01.12 Document Record for copying bluefile rmv				
	KJ				

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

SAD 07/64/02 (P)

2.0	D2570	Bushing
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 192.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
x 24	D2570	Bushing	B30198 - B31224-1 (158)

3.0	D2571	Saddle, Fwd, Out
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle, Fwd, Out

Pick:

Qty	Part Number	Description	Batch
1	D2571	Saddle	B 30094 (7X)
			B 30592 (1X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 3:30:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 31218

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D2572

Saddle, Fwd, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Saddle, Fwd, In

Pick:

Qty	Part Number	Description	Batch
1	D2572	Saddle	153042

B 31146 (7A) ✓

B 30593 (X) ✓

5.0

D2573

Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Saddle, Aft, Out

Pick:

Qty	Part Number	Description	Batch
1	D2573	Saddle	B 30214- ✓

6.0

D2574

Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Saddle, Aft, In

Pick:

Qty	Part Number	Description	Batch
1	D2574	Saddle	B 30097 (6x) ✓

B 30595 (2x) ✓

7.0

D27361

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Lug Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2736-1	Bracket	B 29783- ✓

8.0

D27363

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Lug Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2736-3	Bracket	B 29622 (7) ✓

B 30053 (1) ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: SADDLE KIT

Job Number: 31218

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description:

9.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 32.0000 Each(s)

Set Screw

Pick:

Qty	Part Number	Description	Batch
4	D2747	Socket Head Set Screw	B30054-8 - B30818 (24)

10.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2876	Spacer	B28016

11.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2877	Spacer	B28401

12.0

D2968041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Tow Ring

Pick:

Qty	Part Number	Description	Batch
1	D2968-041	Tow Ring	B27924 (4) B29836 (4)

13.0

D35331

Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Set Screw

Pick:

Batch: B28093

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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User: Kim Johnston

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Drawing Name: SADDLE KIT

Job Number: 31218

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

16

AN4-6A

Bolt

M102115 ✓ ✓

15.0

AN46A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

4

AN4-6A

Bolt

M102985 ✓ ✓

16.0

AN451A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

8

AN4-51A

Bolt

M102832 ✓ ✓

~~M102809~~

17.0

AN612A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

8

AN6-12A

Bolt

M103287

M103830

M102809

18.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 256.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

32

AN960JD416

Washer

M103338 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 01/05/04

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 3:30:06 PM
User: Kim Johnston

Process Sheet

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Drawing Name: SADDLE KIT

Job Number: 31218

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

X 8

AN960JD616

Washer

M103395- ✓

20.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

X 1

AN970-4

Washer

M103344- ✓

21.0

MS21042L4

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 232.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

X 29

MS21042L4

Nut (or MS21042-4)

M103914(138) ✓ M103349 (101) ✓

SAD 07/04/02

(8)

22.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

CP 7/15/03 (8) C 207/05/03 (8)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: A H

CP 7/15/03 (8)

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

CP 07/05/04

(8)

Job Completion



u 07.5.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #1	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED #1	DRAWING NO. K10003	REV. C SHEET 1 OF 1
DATE 06.11.07		TITLE SADDLE KIT	SCALE NTS
A	00.06.01	NEW ISSUE	
B	00.11.22	ADD D2707-041 OPTION	
C	06.11.07	ADD D3533-1	

RELEASED

06.11.13 **#1**

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 205/210/212/412	D205-634-011 D205-634-015
BELL 204	D204-635-011

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10003	D205-634-011 D205-634-015	D204-635-011
D205-641-011	1	1	1
D2570	16	16	16
D2571	1	1	1
D2572	1	1	1
D2573	1	1	1
D2574	1	1	1
D2747	4	4	4
D2876	2	2	2
D2877	2	2	2
D2707-041 (or D2968-041)	1	1	1
D3533-1	2	2	2
AN4-51A	8	8	8
AN4-6A	16	16	16
AN6-12A	8	8	8
AN960JD416	32	32	32
AN960JD616	8	8	8
*AN960JD1016	1	1	1
AN970-4	1	1	1
MS21042-4 (OR L4)	25	25	25

* REQUIRED WITH D2707-041 ONLY

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **31218**

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